

CATEGORY SMAW Stick Electrodes

TYPE High basic electrode for welding duplex stainless steels

APPLICATIONS Used for pipe work and general fabrication in the offshore oil and gas and chemical process industries. Also suitable for cladding steels to obtain corrosion resistant layers..

PROPERTIES A high basic electrode for welding austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types. CEWELD® 4462 Kb has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has a high resistance to intergranular corrosion, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.


CLASSIFICATION

AWS	A 5.4: E 2209
EN ISO	3581-A: E 22 9 3 N L B 22
F-nr	5
FM	5
W.Nr.	1.4462

SUITABLE FOR Duplex stainless steels,
 1.4462, 1.4417, 1.4582, 1.4463, 1.4460, 1.4362, 1.4583, 1.4162
 X2CrNiMoN 22-5-3, X2CrNiN 23 4, X2CrNiMoN21-5-1
 UNS S31803, UNS 32205, UNS 32304, UNS 32101
 UR 45N & UR 45N+, 2205, SAF 2205 Fafer 4462, NKCcr22, SM22Cr, Falc 223, UR 35 N SAF 2304
 P235GH, P265GH, S255N, P295GH, S355N

APPROVALS CE

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N
0.02	0.8	1.1	0.02	0.015	22.5	9.5	3.5	0.18

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V -50°C
As Welded /	620	750	25	95	70

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT (A) DC+/AC	KG / CAN	KG / 6PACK	KG / 1000
2.5	300	45-70	2.4	14.4	18.8
3.2	350	70-110	2.7	16.2	35.6
4.0	350	110-140	2.7	16.2	54

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175